

Work Order ID 131650

Tuesday, April 21, 2015 8:00:44 AM

131650

PRELIMINARY ISSUE

Page 1

Item ID: D5240-041

Accept

N9000040100

Setup Start

NS1

Revision ID: PRELIM



Item Name: Sill Bracket Assembly

Stop

NS2

Start Date: 4/21/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/21/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 1504-21

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D5240

WAS PAS

110

0.00

110

Small Fab

Memo

0.00

Small Fab

ASSEMBLE AS PER DWG

1 FF APR 29 2015

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

① DAS
38
9-89

APR 29 2015

130

0.00

130

SprayPaint

Memo

0.00

Spray Painting

PAINT ONLY SCREWS AND WASHER AS PER DWG NOTE 2

FLAT BLACK PAINT BATCH: 131561

1 DAS
41
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment <input type="checkbox"/> Design <input type="checkbox"/> Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Pre <input type="checkbox"/> Material <input type="checkbox"/> Internal Transport <input type="checkbox"/> Tribal Knowledge <input type="checkbox"/> LOA <input type="checkbox"/> Substation <input type="checkbox"/> Past Expiry Date <input type="checkbox"/> Misidentified <input type="checkbox"/>	No Re-verification <input type="checkbox"/> Operator <input type="checkbox"/> Offset/Setup <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Use for Testing <input type="checkbox"/> Poor Information <input type="checkbox"/> Rushing <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Past Due <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Wave/Twist in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/> Set-up <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Drill Holes <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set <input type="checkbox"/> Misabeled <input type="checkbox"/> Fit/Function <input type="checkbox"/> Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Misread <input type="checkbox"/> Turning Sequence <input type="checkbox"/>	OTHER : _____			

Work Order ID 131650

Tuesday, April 21, 2015 8:00:44 AM

131650**PRELIMINARY ISSUE**

Page 2

Item ID: D5240-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: PRELIM Stop ***NS2***
Item Name: Sill Bracket Assembly
Start Date: 4/21/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/21/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC14- Inspect Spray Paint	0.00							38 9-89

140

QC

Memo

Quality Control

APR 29 2015

150

Identify as per dwg & Stock Location: Prelim 0.00***150***

Packaging

Memo

Packaging

① 15-4-29

160

QC21- Final Inspection - Work Order Release 0.00

160

QC

Memo

Quality Control

① 15-4-29**POSITIVE RECALL**EFFECTIVE 15-4-21 AUTH MLJ

RELEASED _____ DATE _____

RDIS-100#-02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause <div style="display: flex;"> <div style="flex: 1;"> Environment <input type="checkbox"/> Design <input type="checkbox"/> Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Pre <input type="checkbox"/> Material <input type="checkbox"/> Internal Transport <input type="checkbox"/> Tribal Knowledge <input type="checkbox"/> LOA <input type="checkbox"/> Substation <input type="checkbox"/> Past Expiry Date <input type="checkbox"/> Misidentified <input type="checkbox"/> </div> <div style="flex: 1;"> No Re-verification <input type="checkbox"/> Operator <input type="checkbox"/> Offset/Setup <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Use for Testing <input type="checkbox"/> Poor Information <input type="checkbox"/> Rushing <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Past Due <input type="checkbox"/> </div> </div>		FAULT CATEGORY <div style="display: flex;"> <div style="flex: 1;"> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Wave/Twist in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> </div> <div style="flex: 1;"> Temperature/Cure <input type="checkbox"/> Set-up <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Drill Holes <input type="checkbox"/> </div> <div style="flex: 1;"> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set <input type="checkbox"/> Mislabelled <input type="checkbox"/> Fit/Function <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> </div> <div style="flex: 1;"> Positioned Wrong <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Misread <input type="checkbox"/> Turning Sequence <input type="checkbox"/> </div> </div>			
OTHER : <input type="checkbox"/>					

Picklist Print

Tuesday, April 21, 2015 8:00:48 AM

PRELIMINARY ISSUE

Page 1

Work Order ID: 131650

131650

Parent Item: D5240-041

D5240-041

Parent Item Name: Sill Bracket Assembly

Start Date: 4/21/2015

Required Date: 4/21/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.04.20 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5240-043		Manufactured	No				Each	0.0000		1			
D5240-043					R 131649				**	1	FF	APR 29 2015	
Instrument Mount Assembly													
D5240-1		Manufactured	No				Each	0.0000		1			
D5240-1					R 131651				**	1	FF	APR 29 2015	
Horizontal Plate													
MS27039-08-06		Purchased	No				Each	178.0000		2			
MS27039-08-06									**		FF	APR 29 2015	
Screw													

Location

Loc Qty

Loc Code

ST282

178

125646

55

m126249

123

2

NAS1149FN832P

Purchased

No

Each

3,618.000

2

NAS1149FN832P

Washer

**

FF

APR 29 2015

Location

Loc Qty

Loc Code

ST260a

1942

125268

1942

st268

1676

125268

755

M130388

921

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

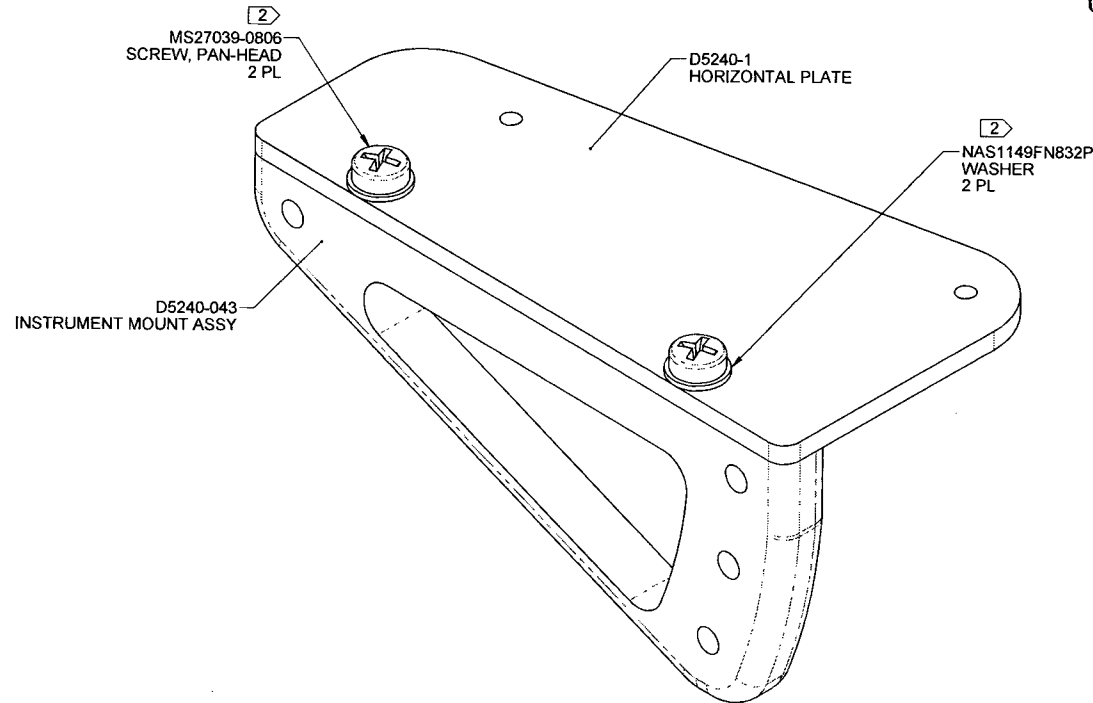
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause <div style="display: flex; flex-wrap: wrap;"> <div style="width: 33%;"> Environment <input type="checkbox"/> Design <input type="checkbox"/> Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Pre <input type="checkbox"/> Material <input type="checkbox"/> Internal Transport <input type="checkbox"/> Tribal Knowledge <input type="checkbox"/> LOA <input type="checkbox"/> Substation <input type="checkbox"/> Past Expiry Date <input type="checkbox"/> Misidentified <input type="checkbox"/> </div> <div style="width: 33%;"> No Re-verification <input type="checkbox"/> Operator <input type="checkbox"/> Offset/Setup <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Use for Testing <input type="checkbox"/> Poor Information <input type="checkbox"/> Rushing <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Past Due <input type="checkbox"/> </div> <div style="width: 33%;"> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Wave/Twist in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> </div> </div>			FAULT CATEGORY <div style="display: flex; flex-wrap: wrap;"> <div style="width: 33%;"> Temperature/Cure <input type="checkbox"/> Set-up <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Drill Holes <input type="checkbox"/> </div> <div style="width: 33%;"> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set <input type="checkbox"/> Mislabeled <input type="checkbox"/> Fit/Function <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> </div> <div style="width: 33%;"> Positioned Wrong <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Misread <input type="checkbox"/> Turning Sequence <input type="checkbox"/> </div> </div>		
OTHER : _____					

PRELIMINARY ISSUE

ITEM	QTY	P/N	DESCRIPTION
	X	D5240-041	SILL BRACKET ASSY
1	1	D5240-1	HORIZONTAL PLATE
2	1	D5240-043	INSTRUMENT MOUNT ASSY
3	2	MS27039-0806	SCREW, PAN-HEAD
4	2	NAS1149FN832P	WASHER



D5240-041 SILL BRACKET ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 131650 MJS
15-04-21

NOTES:

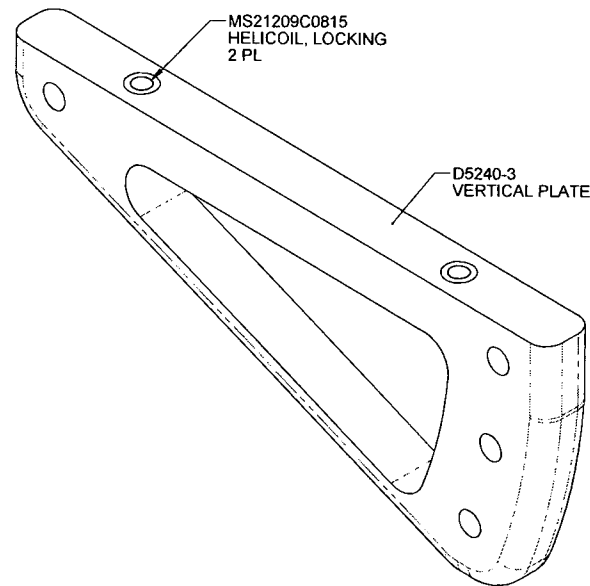
- 1) MATERIAL: N/A
- 2) FINISH: PAINT SCREWS AND WASHERS
PAINT MATTE BLACK PER DART QSI 005 4.2.2.3
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SEE -3
- 7) WEIGHT: 0.21 lbs

PRELIMINARY ISSUE

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	AJS	15.04.16
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. A5
MFG. APPR.	JLM	D5240	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SILL BRACKET ASSY	NTS
DATE	15.04.16	<small>COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

PRELIMINARY ISSUE

ITEM	QTY	P/N	DESCRIPTION
	X	D5240-043	INSTRUMENT MOUNT ASSY
1	1	D5240-3	VERTICAL PLATE
2	2	MS21209C0815	HELICOIL, LOCKING



D5240-043 INSTRUMENT MOUNT ASSY

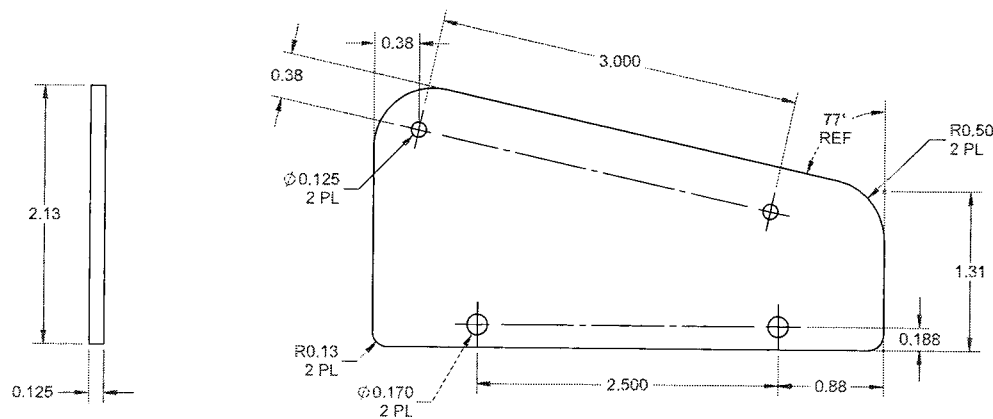
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SEE -3
- 7) WEIGHT: 0.12 lbs

PRELIMINARY ISSUE

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A5
MFG. APPR.	JLM	D5240	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SILL BRACKET ASSY	NTS
DATE	15.04.16	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

PRELIMINARY ISSUE



D5240-1 HORIZONTAL PLATE

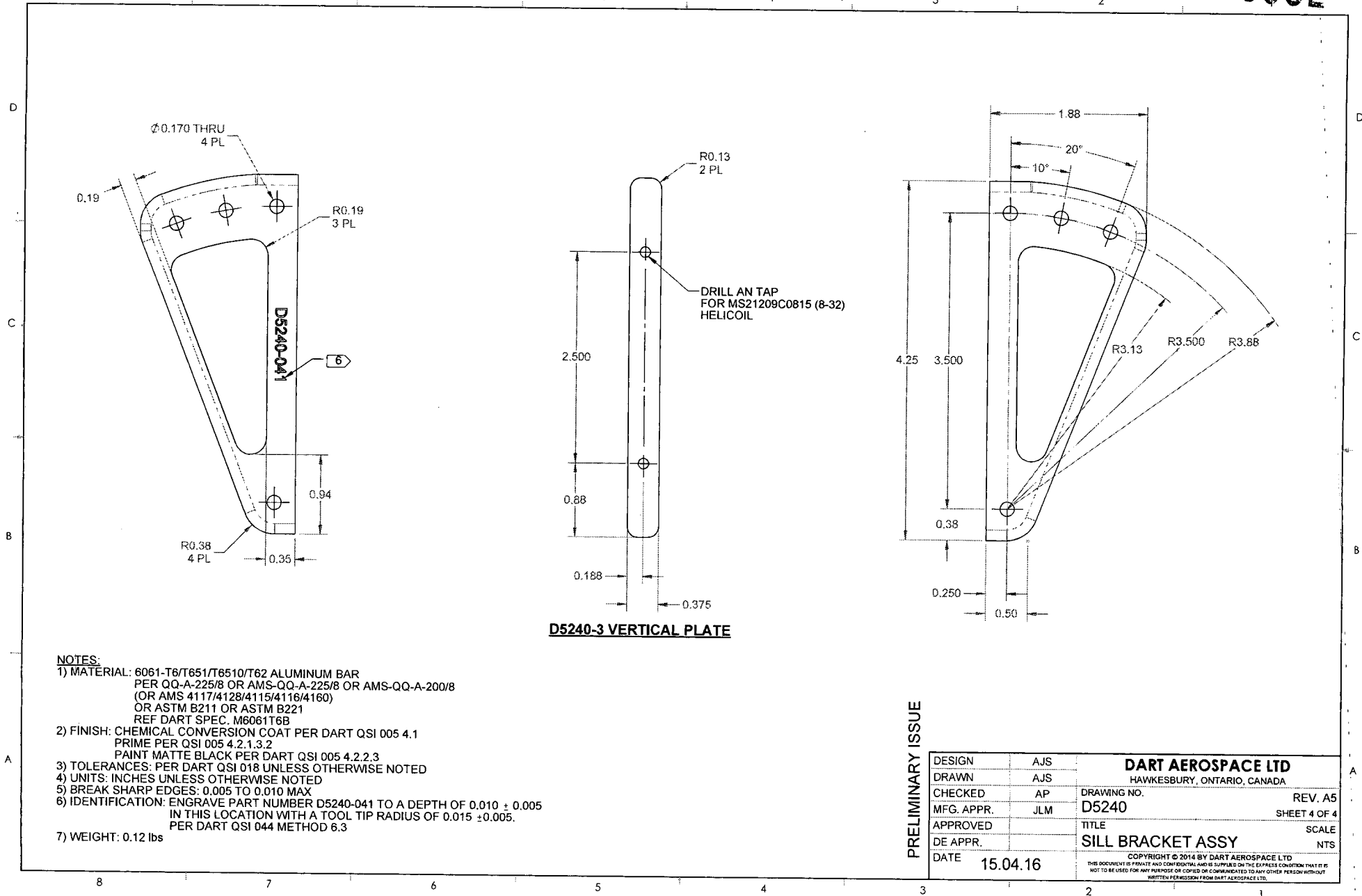
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER QSI 005 4.2.1.3.2
PAINT MATTE BLACK PER DART QSI 005 4.2.2.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: SEE -3
- 7) WEIGHT: 0.09 lbs

PRELIMINARY ISSUE

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A5
MFG. APPR.	JLM	D5240	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SILL BRACKET ASSY	NTS
DATE	15.04.16	COPYRIGHT © 2014 BY DART AEROSPACE LTD	
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PRELIMINARY ISSUE



PRELIMINARY ISSUE

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A5
MFG. APPR.	JLM	D5240	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SILL BRACKET ASSY	NTS
DATE	15.04.16	<small>COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	